Dart Aerospace Ltd. Friday, 28/11/2008 2:53:57 PM Date: Julie Dawson User: **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : BUSHING Job Number : 43844 : 10175 **Estimate Number** P.O. Number : D2570 Part Number : 28/11/2008 This Issue S.O. No. : **Drawing Number** : D2570 REV B Prsht Rev. : NC **Project Number** : N/A First Issue : // Type : MACHINED PARTS : B **Drawing Revision** : 43750 **Previous Run** Material **Due Date** : 20/12/2008 Qty: 500 Um: Written By **Checked & Approved By** Comment Re-format; Removed finishing; Material change K E 02.08.29 est F 07.07.06 EC rev B dwg **Additional Product** Job Number: Seq. #: **Machine Or Operation:** Description: 1.0 M303R0750 IN COMPUTER 303 Round Bar 0.750 Comment: Qty.: 0.0810 f(s)/Unit Total: 40.4775 f(s) Material: Ø0.750 AISI 303 SS Rod (M303R0.750) Batch <u>M118166</u> HARDINGE 2.0 Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA258 Deburr 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8 4.0 SECOND CHECK Comment: SECOND CHECK

PACKAGING RESOURCE #1

5.0

PACKAGING 1

Location:

Comment: PACKAGING RESOURCE #1
Identify and Stock

Each

Dart Aerospace Ltd

W/O:		WORK ORDER					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #· Fault Category:	NCP. V	e No DO	Λ.	Date:	,

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

	· · · · · · · · · · · · · · · · · · ·	WORK ORD	ER NON-CONFORMAN	ICE (NCR)			
	Description of NC		Corrective Action Section		Verification	Annroval	Approval
DATE STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Approval Section C Chief Eng

NOTE: Date & initial all entries

Date:

Friday, 28/11/2008 2:53:57 PM

User:

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 43844

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES					
DATE	STEP	PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·						
		,							
Part No	•	PAR #:	Fault Category:	NC	R: Yes	s No DQ	A :	Date:	
	Resol	ution:	Disposition:	QA	\: N/C (Closed:		Date:	

	•	WORK ORD	ER NON-CONFORMAN	CE (NCR)			
	Description of NC		Corrective Action Section B	3	Monification	A	Approval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC inspector
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	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section E Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Section C Chief Eng

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: ムつなり	4
Description: Bushing	Part Number: D2570	,
Inspection Dwg: D2570 Rev: B	Page 1 c	of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	:798				
0.060	+/-0.005	.060				
R0.010	+0.010/-0.000	R.010				
Ø0.425	+0.000/-0.002	8 4235			-	
Ø0.257	+0.006/-0.001	0.258			_	
Ø0.750	+/-0.010	Ø.748				
0.030 x 20°	+/-0.010	0.022 x 20°				
					,	
	_					
ı					-	

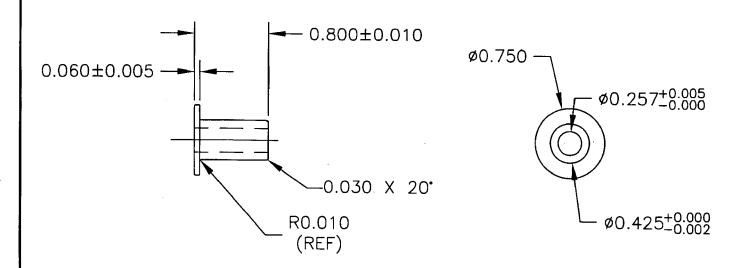
Measured by:	Inf	Audited by:	Prototype Approval:	N/A
Date:	08/12/07	Date: 08//2/08	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
С	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM IA	
D	08.07.23	Tolerance for Ø0.257 revised	KJ/DD 🛠	Z

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DESIGN DRAWN BY		PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECK	KED ##	APPROVED	DRAWING NO.	REV. B	
	一贯	M	D2570	SHEET 1 OF 1	
DATE			TITLE	SCALE	
07.0	04.17		BUSHING	1:1	
Α		96.09.16	NEW ISSUE		
В		07.04.17	UPDATE NOTES		



D2570 BUSHING

D2570 BUSHING

- MATERIAL: 1)
- AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH:
- NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

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